Work Orde <i>May-06-14 10:0</i>		958			*118	3958*							Page 1
Item ID: Revision ID: Item Name:	D3393-041 Battery Lock				Accept	*N900	<u>040</u>	100)* ፡	-	tart Stop		S1* S2*
Start Date: Required Date: Reference:		Start Qty Req'd Qt		*9*		Cust Item l Customer:	ID:					ı W.	17
Approvals:	Process Plan QC:	: MLJ	5	Date: 1405-01	Tooling: _ SPC (Y/N):		ate:		I		tart Stop		R1* R2*
Sequence ID/ Work Center II		Operation Description			Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty		Reject Number	Insp. Stamp
Draw Nbr	Revis	sion Nbr											
D3393	Rev A	4											
*100 *100* Small Fab Small Fab			1-Open D33 and lock bar per Dwg D3	HECK IF KEYED ALIKE 373-1 lock package. Keep rrel. Discard the rest.2-Us 369Identify as D3369-53 ert lock body and fasten	keys, lock body, lock boo	ly nut, flat cam D3369-5 as							FF 14-05-2
110 *1 1 Large Fab Large Fab				ock shaft to flat cam of a Batch A/RN/A	0.00 0.00 Max 1/8" Long OtyPart N SS Rod	lumber			<u></u>	<u>14-05</u>	<u>ટ્ર-જ</u> ી	10)

DQA:			Date:		<u>-</u>									ſ
		•				WORK ORDER NON-	-CC	ONFO	RMANCE / U			_	AEROSPACE	:
QA Closed:			Date:							W	ork Order up	odate only		
						DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
Work Orde	r: _								a	, <u> </u>	٦	ر المعارضة المعارضة ا		
2						Rework			Skid-tube	Crosstube	- Dra	Water Jet	Engineering Quality	
Part N	o. <u>-</u>		* * * * * * * * * * * * * * * * * * * *			Scrap			Machining	Small Fab Finishing	-	d. Eng. Coor. re/Packaging	Other	
NCR N	^					Use-as-is Suspected Unapproved		mem	Large Fab	Composite	1 100/3101	Supplier		
INCK IN	·-					Suspected Onapproved	l		Large Tab	composite	_	and bure.		
Root	T				Desci	ription of work order update		nitial	Act	ion	Sign &			_
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector	
Design						:								
Doc/Data												1		
Equip/Tooling					1									
Handling/Pre	╝													
Material	╝													
Operator	_													
Offset/Setup														
Process	4		:											
Supplier	_													
Training	4													
Transport	4													
Unapproved			<u> </u>	l	l		EA	III T CA	I TEGORY	.	<u> </u>			_
Landin	G	ear				General	FA	OLI CA	IEGORT	·				_
	_	Bending				Bend	Г]Folio/F	Program	Г	Outside Dim	ensions [Pressure/Forced	
<u> </u>	_	Centre No	ot Concer	ntric		BOM/Route	H	Grain			Over/Under	<u> </u>	Set-up	
	_	Cracks				Broken/Damage/Defect		Hardwa	are	<u> </u>	Part Incorre	ci	Temperature/Cure	
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	Part Lost/Mi	issing	Weld	
	-	Cuffs				Contamination		Instruct	tions Incomplete/U	Jnclear	Part Moved	[Wrong Stock Pulled	
		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong	<u> </u>	
		Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge [Other	
		Inspectio	n Strip in	Tube		Drawing		Misrea	d					
		Marks/Ch	natter			Drill Holes		Off-set						
	$\overline{}$	Turning S				Finish		4	Calibration					
		Wave/Tw	ist in Tub	e		Fit/Function	L	Out of	Sequence					

Work Ord <i>May-06-14 10:</i>		8958		*118	8958*							Page 2
Item ID: Revision ID: Item Name:	D3393-041 Battery Lock			Accept	*N900	040	100)*	Setup	Start Stop	*N:	S1* S2*
Start Date: Required Date Reference:	5/05/14 e: 5/05/14	Start Qty: 2.00 Req'd Qty: 2.00	*9* *9*		Cust Item l Customer:	D:					13.	
Approvals:	Process Pla	nn:	Date:	Tooling: _ SPC (Y/N):		ate:	-			Start Stop		R1* R2*
Sequence ID/ Work Center I 120 *120* QC Quality Control	ID	Operation Description QC9- Inspect visual per Memo	QS1004- Fusion Welds	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp DAS 24) / 9-89
120 Small Fab Small Fab		Small Fab Memo Apply Crazz Batch:	y Glue to cap and press i 12624 ₀	0.00 0.00 nto Body 9567K21				9_				FF 14-05-21
140 , *1 4 0 * QC		QC5- Inspect part compl	leteness to step on W/O	DAS 27 0.00 \$ \$9 \(\sqrt{1}\)\(\sqrt{2}\)\(\sqrt{2}\)	$\mathcal{Q}_{\mathcal{Q}}$			<u></u>				

Quality Control

DQA:			Date:						_				TRAC
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:				_			W	ork Order up	date only	
Work Orde	or.					DISPOSITION			AGAIN	IST DI	PARTMENT	/PROCESS	
WOIR OIG	-''-					Rework	1		Skid-tube Crosstu	he	1	Water Jet	Engineering
Part N	io.					Scrap			Machining Small F		Pro	d. Eng. Coor.	Quality
	•	<u> </u>				Use-as-is			noforming Finish		4	re/Packaging	Other
NCR N	١o.					Suspected Unapproved			Large Fab Compos	~ ⊢		Supplier	1 1
	_			-			•	L			- ,	<u>. </u>	
Root					Desci	ription of work order update	Ī	Initial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
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Handling/Pre													
Material 🦫 🧖						•	1						
Operator	Ш												
Offset/Setup												-	
Process													
Supplier													
Training									·				
Transport													
Unapproved							<u></u>						
							FA	ULT CAT	TEGORY			•	
Landi						General		,		г	7	_	-
	\vdash	Bending				Bend	<u></u>	4	Program		Outside Dim	 	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain		<u> </u>	Over/Under	F	Set-up
	\vdash	Cracks				Broken/Damage/Defect		Hardwa			Part Incorre	<u> </u>	Temperature/Cure
		Crimp/Kir	ık/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified	L	Part Lost/Mi	ssing	Weld
		Cuffs			<u> </u>	Contamination		-1	tions Incomplete/Unclear	L	Part Moved	L	Wrong Stock Pulled
	Ш	Crushing				Countersink	_	4 -	gned/off center		Positioned V		·
		Heat Trea	it			Cut Too Short		Mislabe			Power Loss/	Surge	Other
		Inspection	•	Tube		Drawing		Misread					
	\vdash	Marks/Ch				Drill Holes		Off-set					
	-	Turning S			L	Finish	$ldsymbol{ld}}}}}}$	4	Calibration				
		Wave/Tw	ist in Tub	oe		Fit/Function		Out of	Sequence				

Work Ord <i>May-06-14 10:</i>		3958		*118	3958*				1421			Page 3
Item ID: Revision ID:	D3393-041			Accept	*N900	040	100)* :	Setup	Start	*N	S1*
Item Name:	Battery Lock									Stop	*NI	S2*
Start Date: Required Date	5/05/14 : 5/05/14	Start Qty: 2.00 Req'd Qty: 2.00	*9*		Cust Item I Customer:	D:						. 17
Reference:	,,				Customer.							
Approvals:	Process Plan	n:	Date:	Tooling:	Da	ate:	•]	Run	Start	*N	R1*
	QC:		Date:	_ SPC (Y/N):	Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center I		Operation Description Identify as per dwg & Stock	k Location:	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
150 Packaging Packaging		Мето	-3-7 /	0.00				<u> 2x</u>	· -		4-	5-22
*160 *		QC21- Final Inspection - W	Vork Order Release	0.00						14/	5/2	24
QC :		Memo		0.00						<u> </u>	-	'

Quality Control

MW 1405-22

DQA:			Date:										TRACT
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE			–	AEROSPACE
QA Closed:			Date:							W	ork Order up	odate only	
Work Orde	or.					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS	
WOIR OIG	-				—	Rework			Skid-tube Crosstube	Γ	1	Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fab		Pro	d. Eng. Coor.	Quality
	-					Use-as-is			noforming Finishing	┝	1	re/Packaging	Other
NCR N	۱o. <u>-</u>					Suspected Unapproved			Large Fab Composite]	Supplier	
Root	-				Desci	ription of work order update		nitial	Action		Sign &		T
Cause		Date	Step	Qty	Desci	or non-conformance		ief Eng			Date	Verification	QC Inspector
Design			Otop	۵.,									
Doc/Data			ę.										
Equip/Tooling													
Handling/Pre													
Material			 										
Operator				İ									
Offset/Setup													
Process							ŀ						
Supplier													
Training													
Transport				•									
Unapproved												.,	
							FAI	ULT CA	TEGORY				
Landi					_	General		1 .		_	7	· ·	- .
	Н	Bending				Bend	Щ	1	Program	_	Outside Dim		Pressure/Forced
	Н	Centre No	ot Concer	ntric	-	BOM/Route		Grain		_	Over/Under	<u> </u>	Set-up
		Cracks				Broken/Damage/Defect		Hardwa		<u> </u>	Part Incorred	├	Temperature/Cure
	${f -}$	Crimp/Kir	nk/Ripple	/Wave	<u> </u>	Burrs		1	ion Incomplete/Unqualified	<u> </u>	Part Lost/Mi	ssing	Weld
	Н	Cuffs			<u> </u>	Contamination	<u> </u>	4	tions Incomplete/Unclear	<u> </u>	Part Moved	. <i>.</i>	Wrong Stock Pulled
	—	Crushing	_		<u> </u>	Countersink	-		gned/off center	\vdash	Positioned V		
	-	Heat Trea		- .	<u> </u>	Cut Too Short	-	Mislabe			Power Loss/	Surge	Other
	-	Inspection	-	Tube	<u> </u>	Drawing	\vdash	Misrea					· · · · · · · · · · · · · · · · · · ·
		Marks/Ch				Drill Holes	\vdash	Off-set			<u> </u>		
		Turning S			\vdash	Finish	\vdash	4	Calibration		-		·
	ll	Wave/Tw	ist in Tub	oe .		Fit/Function		Out of :	Sequence				

Picklist Print

May-06-14 8:08:04 AM

Work Order ID: 118958

118958

Parent Item:

D3393-041

D3393-041

Parent Item Name: Battery Lock

Start Date: 5/05/14

Required Date: 5/05/14

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty // Issued	Date Status Issued
5/16WC		Purchased	No			100	Each	457.0000	2	4		
5/16WC									**		FF	14-05-2
				Location		Loc	<u>Oty</u>	Loc Code				
•				ST365			457					
05/71/21					M127961		457			4	_ :	
9567K21		Purchased	No			100	Each	9.0000	2	4		_
9567K21 Polyetheline Cap	ı								**		FF	14-05-
			-	Location		Loc	<u>Oty</u>	Loc Code				
				ST381			9		-		_	
					120743		9		_	<u>Ø</u> '	_	
D3373-1		Manufactured	No	•		100	Each	26.0000	1	2		-
D3373-1									**		FF	14-05-
•				Location		Loc	<u>Otv</u>	Loc Code				
				GA			20		`		_	
					105986		20		_	2		
				ST040	5 404 5		6		_		<u>-</u>	
D3393-1		Monufacture	No	•	74862	100	6 East	1 0000	_		_	
		Manufactured	140			100	Each	1.0000	1	2		
D3393-1 Battery Lock Casing									**		FF	14-05-21

Location ST492

Loc Oty

Loc Code

DQA:			Date:			,							TRACT
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / U		/ork Order uj	odate only	AEROSPACE
QA Closed.			Dute.			DISPOSITION			·				
Work Orde	r:					DISPOSITION				AGAINST D	EPARTMENT, —	/PROCESS —	
			•			Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	o					Scrap		1	Machining	Small Fab		d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	o. —					Suspected Unapproved]		Large Fab	Composite		Supplier	
Root	Т				Desci	ription of work order update		Initial	Act	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling	_			·								<u> </u>	
Handling/Pre	4												
Material	_						1			•			
Operator	4										Ì		
Offset/Setup	\dashv												
Process	4								:				
Supplier	\dashv												
Training	-												
Transport	_				İ							İ	
Unapproved					I		FΑ	ULT CA	TEGORY		<u></u>		<u></u>
Landin	g Ge	ar	<u></u>			General							
	_	ending				Bend]Folio/F	Program	Γ	Outside Dim	ensions	Pressure/Forced
		-	t Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	\neg c	racks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ci 📗	Temperature/Cure
		rimp/Kin	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ui	nqualified	Part Lost/M	issing	Weld
	c	uffs				Contamination		Instruct	tions Incomplete/l	Unclear	Part Moved		Wrong Stock Pulled
	c	rushing				Countersink		Misali	gned/off center		Positioned V	Wrong	_
	н	eat Trea	t			Cut Too Short		Mislabe	eled		Power Loss/	'Surge	Other
	lr	spection	n Strip in	Tube		Drawing		Misrea	d				
	N	1arks/Ch	atter			Drill Holes		Off-set					-
	T	urning S	equence			Finish		Out of	Calibration			_	
		/ave/Tw	ist in Tub	oe		Fit/Function		Out of	Sequence				

Picklist Print

May-06-14 8:08:04 AM

Page 2

Work Order ID: 118958

118958

Parent Item:

D3393-041

D3393-041

Parent Item Name: Battery Lock

Start Date: 5/05/14

Required Date: 5/05/14

Start Qty: 2.00

Required Qty: 2.00

D3393-3

Manufactured

140

Each 20.0000

Cam Lock Shaft

**

14.05-21

Loc Oty Location Loc Code ST041 20 101110 108529 109126 12

May-06-14 8:08:04 AM

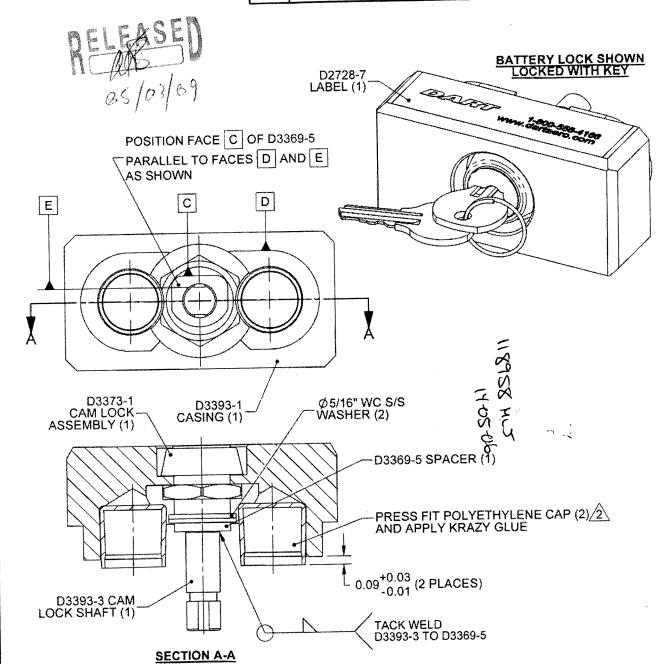
Shop Packet Print

Page 2

DQA:			Date:						•					TAAC"
						WORK ORDER NON-	·CC	ONFO	RMANCE / U			1.0.1		AEROSPACE
QA Closed:		-	Date:				_				W	ork Order up	date only	
Work Orde	ır.					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS	
WOIR OIG	-''-					Rework			Skid-tube	Crosstube			Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	Quality
	_					Use-as-is			noforming	Finishing			re/Packaging	Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite			Supplier	
Root					Desci	ription of work order update	I	nitial	Act	ion		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	QC Inspector
Design	_													·
Doc/Data	_													
Equip/Tooling	_													
Handling/Pre														
Material	Ш													
Operator	_		:											
Offset/Setup	_													
Process	_													
Supplier	_												-	
Training	\dashv													
Transport	\dashv													
Unapproved					<u> </u>			UT CA	FECORY					
المصطائد	C					General	FA	OLI CA	regory					
Landi		ear Bending				Bend] 	rogram	ı		Outside Dim	ensions [Pressure/Forced
	-	Centre No	ot Concer	ntric	\vdash	BOM/Route		Grain	Togram			Over/Under	_	Set-up
	-	Cracks	or concer	ILLIC	\vdash	Broken/Damage/Defect		Hardwa	are.			Part Incorre	<u> </u>	Temperature/Cure
	-	cracks Crimp/Kir	k/Rinnle	/\ <i>M</i> >ve	-	Burrs		4	ion Incomplete/Ur	ngualified		Part Lost/Mi	_	Weld
	$\boldsymbol{\vdash}$	Cuffs	ik) hippic	., wave	-	Contamination		1 '	ions Incomplete/l	· 1		Part Moved	- I	Wrong Stock Pulled
	-	Crushing				Countersink	┢	4	ned/off center			Positioned V	∟∟ Vrong	
	\vdash	Heat Trea	t			Cut Too Short	-	Mislabe				Power Loss/		Other
*	\vdash	Inspection		Tube	-	Drawing		Misrea					·	•
	_	Marks/Ch	•			Drill Holes		Off-set						
	\vdash	Turning S				Finish		Out of	Calibration					
	_	Wave/Tw	•			Fit/Function		Out of	Sequence					



DESIGN	3	DRAWNBY	DART AEROSP HAWKESBURY, ONTA	
CHECK	ED -	APPROVED	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE	05.	02.08	BATTERY LOCK	SCALE 1:1
A		05.02.08	NEW ISSUE	



D3393-041 BATTERY LOCK ASSEMBLY

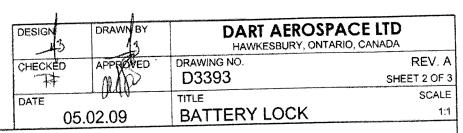
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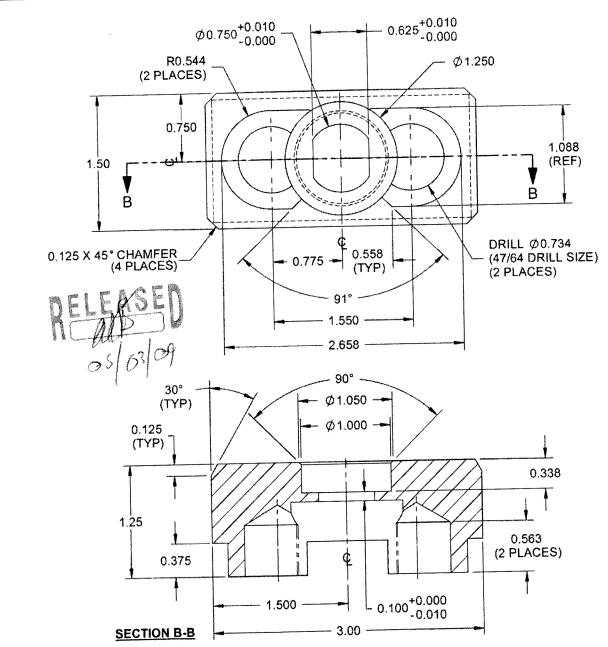
- 1) WELD PER DART QSI 004 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

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D3393-1 CASING

NOTES:

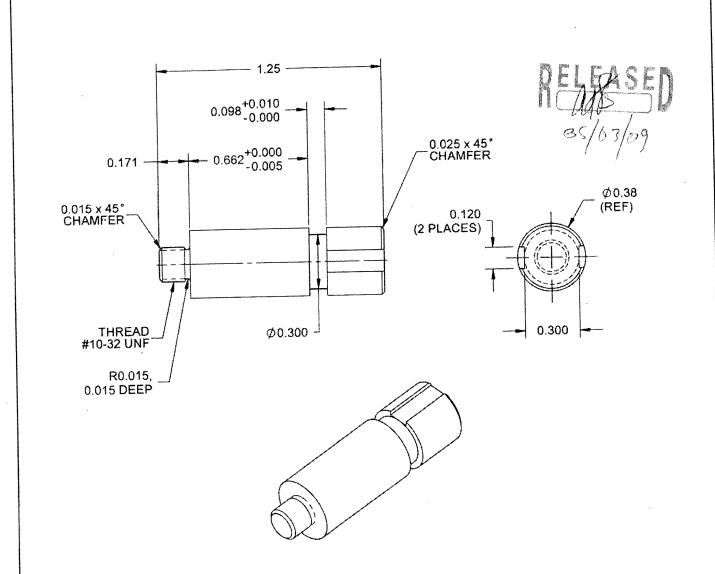
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
 (REF. DART SPEC. M6061T6B)
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DESIGN 3	DRAWN BY	DART AEROSPA HAWKESBURY, ONTAR	
CHECKED TAT	APPROVED	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05	.02.09	BATTERY LOCK	SCALE 2:1



D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) ALL DIMENSIONS ARE IN INCHES
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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